

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021437**Date Inspected:** 05-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Qui Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 008458

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. SEG3020BB-046

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint FB3329-001- 014 located on Floor Beam Stiffener of OBG Segment 14W. ZPMC Welders are identified as 051348, 067572 and 045246. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1

SMAW welding of weld joint SEG3020L-152 located on Anchor Plate to Floor Beam Stiffeners of OBG Segment

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

14W. ZPMC Welder is identified as 067707. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020N-165, 166, 167, 168 169 and 170 located on Anchor Plate to Floor Beam Stiffeners of OBG Segment 14W. ZPMC Welder is identified as 067993. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing on Anchor Plate to Vertical Sear Plate 'T' joint weld at panel point 126 bike path of OBG Segment 14W. The weld numbers are identified as SEG3020BB-109, 110, 111, 116 and 117.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3013-012 located on Deck Panel to Deck Panel of OBG Segment 13AW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1-T-ESAB.

SMAW welding of weld joint SEG3013P-003 and 002 located on Deck Panel Diaphragm to Deck Panel Diaphragm at panel point 118 of OBG Segment 13AW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint SEG3013M-016 and 012 located on Deck Panel Diaphragm to Deck Panel Diaphragm at panel point 117 of OBG Segment 13AW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint DP3122-001-011 and 012 located on Deck Panel Diaphragm to Longitudinal Diaphragm at panel point 118 of OBG Segment 13AW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

FCAW welding of weld joint SEG3013AH-035 located on Floor Beam Stiffener to K-Plate of OBG Segment 13AW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Liu Fang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SA3231D-002 located on sub assembly component OBG Segment 13BW. ZPMC Welder is identified as 204730. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

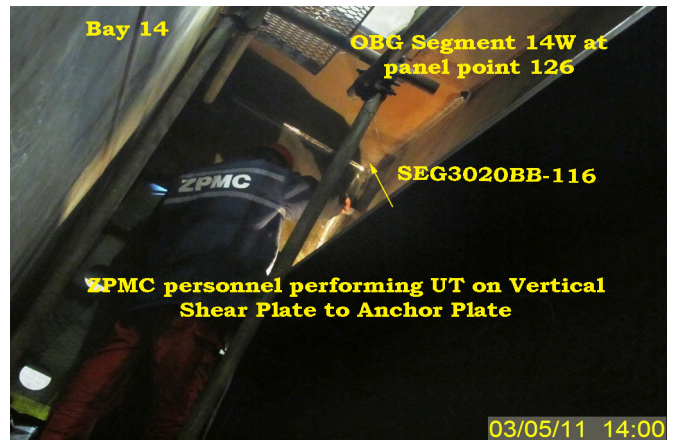
SMAW repair welding of weld joint DP3174-001-034 located on Deck Panel Diaphragm to Deck panel of OBG Segment 14W. ZPMC Welder is identified as 066002. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G-(2F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2846.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

SMAW welding of weld joint SA3031-001 located sub assembly component OBG Segment 13BW. ZPMC Welder is identified as 066179. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Vibin | Quality Assurance Inspector |
| Reviewed By: | Patel,Hiranch | QA Reviewer |
